

FIG. 1

<span style="float: left;">◀</span> <b>AUTO PROCESS SETTING</b> <span style="float: right;">▶</span>														
FUNCTION/TIME SETTING					FUNCTION/TIME SETTING					<input checked="" type="checkbox"/> 2002/12/20 0:21:20				
<div style="display: flex; justify-content: space-between;"> <span>MOVEMENT: ONE</span> <span>TWO</span> <span>THREE</span> <span>FOUR</span> <span>FIVE</span> <span>SIX</span> <span>SEVEN</span> <span>EIGHT</span> <span>NINE</span> <span>TEN</span> <span>NEXT</span> </div> <div style="display: flex; justify-content: space-between; align-items: center;"> <span>END OF MOLD-OPENING ▶</span> <span>02 ▶</span> <span>01 ▶</span> <span>03 ▶</span> <span>15 ▶</span> <span>04 ▶</span> <span>14 ▶</span> <span>NO ▶</span> <span>NO ▶</span> <span>NO ▶</span> <span>NO ▶</span> <span>CYCLE</span> </div>														
<div style="display: flex; justify-content: space-between;"> <span>MOVEMENT: ONE</span> <span>TWO</span> <span>THREE</span> <span>FOUR</span> <span>FIVE</span> <span></span> </div> <div style="display: flex; justify-content: space-between; align-items: center;"> <span>END OF MOLD-CLOSING ▶</span> <span>NO ▶</span> <span>01 ▶</span> <span>NO ▶</span> <span>NO ▶</span> <span>NO ▶</span> <span>MOLD-OPEN</span> </div> <div style="display: flex; justify-content: space-between; margin-top: 5px;"> <span>NO(NO MOVEMENT) <span style="border: 1px solid black; padding: 0 10px;"> </span></span> <span>NO(NO MOVEMENT) <span style="border: 1px solid black; padding: 0 10px;"> </span></span> <span>NO(NO MOVEMENT) <span style="border: 1px solid black; padding: 0 10px;"> </span></span> </div> <div style="display: flex; justify-content: space-between; margin-top: 5px;"> <div style="width: 20%;">           1.MID-EJ-BWD 2.GATE-VA ON         </div> <div style="width: 20%;">           1.MID-EJ-BWD 2.GATE-VA OFF         </div> <div style="width: 20%;">           1.MID-EJ-BWD 2.GATE-VA ON         </div> <div style="width: 20%;">           1.MID-EJ-BWD 2.GATE-VA OFF         </div> </div>														
<div style="display: flex;"> <div style="flex: 1; border-right: 1px solid black; padding-right: 5px;"> <div style="border: 1px solid black; padding: 2px; margin-bottom: 5px;">OPTIONS AFTER END OF MOLD-CLOSING</div> <div style="font-size: 0.8em;">           NO.NO MOVEMENT   6.CORE ONE OUT   12.ROTA-FWD CORE-1-F.B.            1.ROTATE MODE   7.CORE ONE IN   ROTA-BWD CORE-2-F.B.            2.MID-EFJ-FWD   8.CORE TWO OUT   13.FR-BA-EJ-BWD            3.MID-EJ-BWD   9.CORE TWO IN   14.CYC-END            4.FR-BA-EJ   10.GATE-VA OFF   15.OP-CL-DOOR            5.MID-FR-EJ   11.BATE-VA ON         </div> </div> <div style="flex: 1; padding-left: 5px;"> <div style="border: 1px solid black; height: 20px; margin-bottom: 5px;"></div> <div style="font-size: 0.8em;">           NO.(NO MOVE)            1.BI-COLOR INJ.            2.FRONT INJ.   <span style="border: 1px solid black; padding: 0 10px;"> </span>   <span style="border: 1px solid black; padding: 0 5px;">IN SEQUENCE</span>            3.REAR INJ.   <span style="border: 1px solid black; padding: 0 10px;"> </span>  <div style="display: flex; align-items: center; margin-top: 5px;"> <div style="border: 1px solid black; padding: 2px; font-size: 0.7em;">POSITION OF ROTARY PLATE</div> <span style="border: 1px solid black; padding: 0 10px; margin-left: 5px;"> </span> </div> </div> </div> </div>														
<div style="display: flex; align-items: center;"> <div style="margin-right: 10px;"> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> </div> <div style="flex-grow: 1; border: 1px solid black; height: 20px;"></div> </div>														

FIG. 2

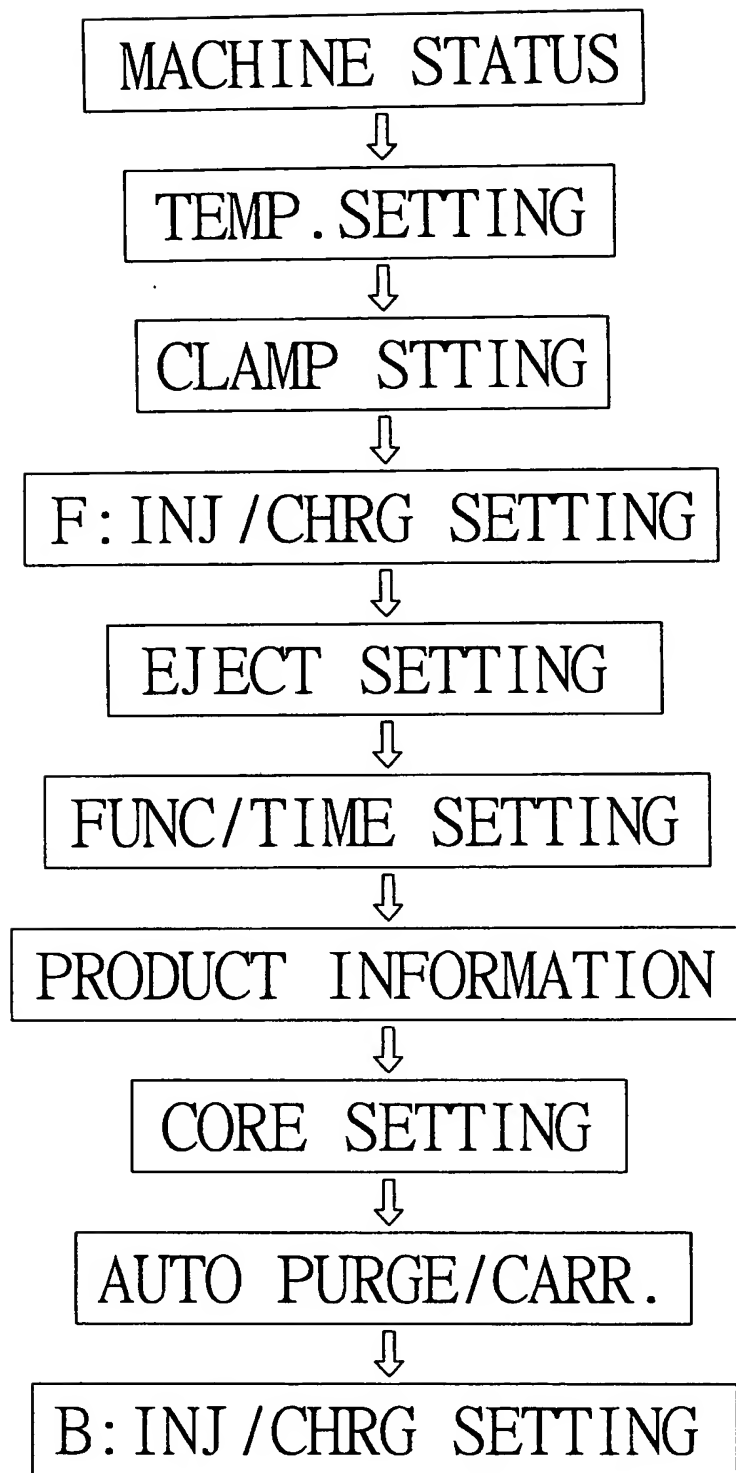


FIG. 3 (PRIOR ART)

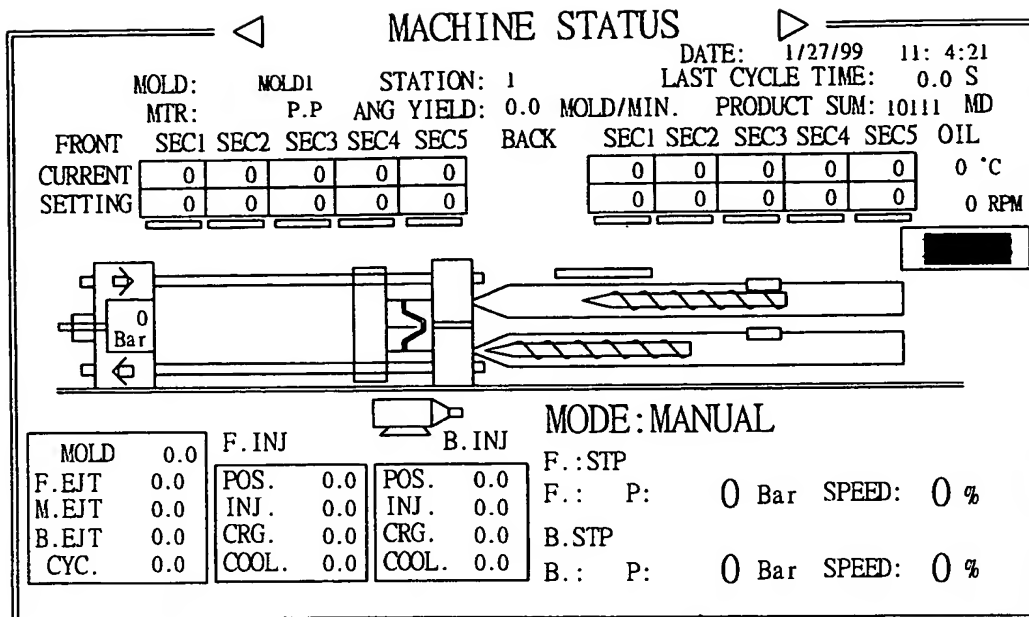


FIG. 4 (PRIOR ART)

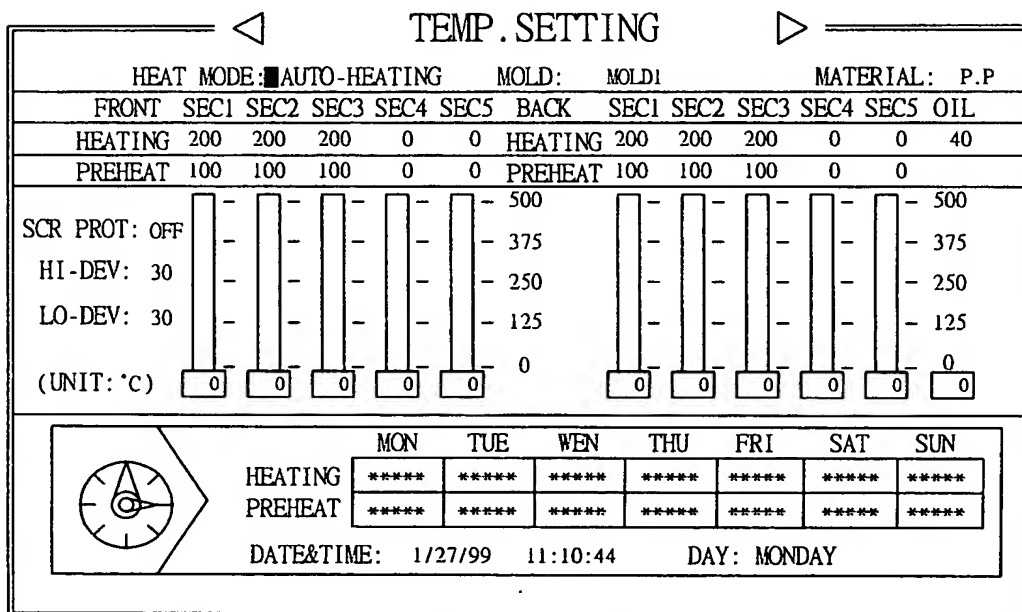


FIG. 5 (PRIOR ART)




CLAMP SETTING																									
MOLD: MOLD1 L_P_T: 0.0 S MOLD POS: 0.0 mm																									
CLAMP-P <input type="text" value="0"/> Bar 	<table border="1"> <thead> <tr> <th></th> <th>FAST</th> <th>SLOW</th> <th>L-P</th> <th>H-P</th> <th></th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td><input type="text" value="140"/></td> <td><input type="text" value="30"/></td> <td><input type="text" value="40"/></td> <td><input type="text" value="140"/></td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td><input type="text" value="99"/></td> <td><input type="text" value="50"/></td> <td><input type="text" value="40"/></td> <td><input type="text" value="99"/></td> <td>%</td> </tr> <tr> <td>POS.</td> <td><input type="text" value="160"/></td> <td><input type="text" value="100"/></td> <td><input type="text" value="0.5"/></td> <td><input type="text" value="0.5"/></td> <td>mm</td> </tr> </tbody> </table> <p>L_P_PROT: 6.0 sec FAST CLAMP: OFF CLAMP FORCE: 360 TON</p>		FAST	SLOW	L-P	H-P		PRES	<input type="text" value="140"/>	<input type="text" value="30"/>	<input type="text" value="40"/>	<input type="text" value="140"/>	Bar	SPEED	<input type="text" value="99"/>	<input type="text" value="50"/>	<input type="text" value="40"/>	<input type="text" value="99"/>	%	POS.	<input type="text" value="160"/>	<input type="text" value="100"/>	<input type="text" value="0.5"/>	<input type="text" value="0.5"/>	mm
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OPEN 	<table border="1"> <thead> <tr> <th></th> <th>DEC.</th> <th>MID</th> <th>FAST</th> <th>SLOW</th> <th></th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td><input type="text" value="30"/></td> <td><input type="text" value="30"/></td> <td><input type="text" value="30"/></td> <td><input type="text" value="140"/></td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td><input type="text" value="99"/></td> <td><input type="text" value="50"/></td> <td><input type="text" value="40"/></td> <td><input type="text" value="99"/></td> <td>%</td> </tr> <tr> <td>POS.</td> <td><input type="text" value="600"/></td> <td><input type="text" value="540"/></td> <td><input type="text" value="50"/></td> <td><input type="text" value="50"/></td> <td>mm</td> </tr> </tbody> </table> <p>OP-LIM.: 1000 mm OP_MD_PROT: 5.0 sec SPRING MOLD: OFF</p>		DEC.	MID	FAST	SLOW		PRES	<input type="text" value="30"/>	<input type="text" value="30"/>	<input type="text" value="30"/>	<input type="text" value="140"/>	Bar	SPEED	<input type="text" value="99"/>	<input type="text" value="50"/>	<input type="text" value="40"/>	<input type="text" value="99"/>	%	POS.	<input type="text" value="600"/>	<input type="text" value="540"/>	<input type="text" value="50"/>	<input type="text" value="50"/>	mm
	DEC.	MID	FAST	SLOW																					
PRES	<input type="text" value="30"/>	<input type="text" value="30"/>	<input type="text" value="30"/>	<input type="text" value="140"/>	Bar																				
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POS.	<input type="text" value="600"/>	<input type="text" value="540"/>	<input type="text" value="50"/>	<input type="text" value="50"/>	mm																				
MOLD-ADJ. 	<table border="1"> <thead> <tr> <th></th> <th>MV-BWD</th> <th>CLAMP</th> <th>MV-FWD</th> <th></th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td><input type="text" value="40"/></td> <td><input type="text" value="40"/></td> <td><input type="text" value="40"/></td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td><input type="text" value="30"/></td> <td><input type="text" value="20"/></td> <td><input type="text" value="30"/></td> <td>%</td> </tr> <tr> <td>PS</td> <td><input type="text" value="0"/></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>		MV-BWD	CLAMP	MV-FWD		PRES	<input type="text" value="40"/>	<input type="text" value="40"/>	<input type="text" value="40"/>	Bar	SPEED	<input type="text" value="30"/>	<input type="text" value="20"/>	<input type="text" value="30"/>	%	PS	<input type="text" value="0"/>							
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SPEED	<input type="text" value="30"/>	<input type="text" value="20"/>	<input type="text" value="30"/>	%																					
PS	<input type="text" value="0"/>																								

FIG. 6(PRIOR ART)

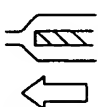
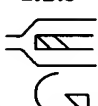

F: INJ /CHRG SETTING																																				
CHRG LIMIT: 470.0 mm INJ. POS.: 0.0																																				
INJECTION USE: <input checked="" type="checkbox"/> OFF SUCK MODE: OFF COOL TM: 0.0																																				
INJECTION 	<table border="1"> <thead> <tr> <th></th> <th>HOLD2</th> <th>HOLD1</th> <th>INJ3</th> <th>INJ2</th> <th>INJ1</th> <th></th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td><input type="text" value="0"/></td> <td><input type="text" value="10"/></td> <td><input type="text" value="0"/></td> <td><input type="text" value="0"/></td> <td><input type="text" value="60"/></td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td><input type="text" value="0"/></td> <td><input type="text" value="20"/></td> <td><input type="text" value="0"/></td> <td><input type="text" value="0"/></td> <td><input type="text" value="80"/></td> <td>%</td> </tr> <tr> <td>TIME</td> <td><input type="text" value="0.0"/></td> <td><input type="text" value="0.5"/></td> <td><input type="text" value="0.60"/></td> <td><input type="text" value="0.60"/></td> <td><input type="text" value="10.0"/></td> <td>sec</td> </tr> <tr> <td>POS.</td> <td><input type="text" value="*****"/></td> <td><input type="text" value="0.0"/></td> <td><input type="text" value="0.0"/></td> <td><input type="text" value="10.0"/></td> <td><input type="text" value="10.0"/></td> <td>mm</td> </tr> </tbody> </table>		HOLD2	HOLD1	INJ3	INJ2	INJ1		PRES	<input type="text" value="0"/>	<input type="text" value="10"/>	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="60"/>	Bar	SPEED	<input type="text" value="0"/>	<input type="text" value="20"/>	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="80"/>	%	TIME	<input type="text" value="0.0"/>	<input type="text" value="0.5"/>	<input type="text" value="0.60"/>	<input type="text" value="0.60"/>	<input type="text" value="10.0"/>	sec	POS.	<input type="text" value="*****"/>	<input type="text" value="0.0"/>	<input type="text" value="0.0"/>	<input type="text" value="10.0"/>	<input type="text" value="10.0"/>	mm
	HOLD2	HOLD1	INJ3	INJ2	INJ1																															
PRES	<input type="text" value="0"/>	<input type="text" value="10"/>	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="60"/>	Bar																														
SPEED	<input type="text" value="0"/>	<input type="text" value="20"/>	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="80"/>	%																														
TIME	<input type="text" value="0.0"/>	<input type="text" value="0.5"/>	<input type="text" value="0.60"/>	<input type="text" value="0.60"/>	<input type="text" value="10.0"/>	sec																														
POS.	<input type="text" value="*****"/>	<input type="text" value="0.0"/>	<input type="text" value="0.0"/>	<input type="text" value="10.0"/>	<input type="text" value="10.0"/>	mm																														
SHRG 	<table border="1"> <thead> <tr> <th></th> <th>CHRG1</th> <th>CHRG2</th> <th>POSTSCK</th> <th></th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td><input type="text" value="0"/></td> <td><input type="text" value="0"/></td> <td><input type="text" value="40"/></td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td><input type="text" value="0"/></td> <td><input type="text" value="99"/></td> <td><input type="text" value="40"/></td> <td>%</td> </tr> <tr> <td>SYS-PRES</td> <td><input type="text" value="0"/></td> <td><input type="text" value="0"/></td> <td><input type="text" value="0"/></td> <td>Bar</td> </tr> <tr> <td>POS.</td> <td><input type="text" value="0.0"/></td> <td><input type="text" value="100.0"/></td> <td><input type="text" value="0"/></td> <td>mm</td> </tr> </tbody> </table> <p>INJ. STL MODE: POS. or TM</p>		CHRG1	CHRG2	POSTSCK		PRES	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="40"/>	Bar	SPEED	<input type="text" value="0"/>	<input type="text" value="99"/>	<input type="text" value="40"/>	%	SYS-PRES	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="0"/>	Bar	POS.	<input type="text" value="0.0"/>	<input type="text" value="100.0"/>	<input type="text" value="0"/>	mm										
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CARR 	<table border="1"> <thead> <tr> <th></th> <th>FWD</th> <th>BWD</th> <th></th> <th>PRE TEST</th> <th>acc USE</th> <th></th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td><input type="text" value="20"/></td> <td><input type="text" value="20"/></td> <td>Bar</td> <td><input type="text" value="OFF"/></td> <td><input type="text" value="OFF"/></td> <td></td> </tr> <tr> <td>SPEED</td> <td><input type="text" value="20"/></td> <td><input type="text" value="20"/></td> <td>%</td> <td><input type="text" value="0"/></td> <td><input type="text" value="10"/></td> <td>Bar</td> </tr> <tr> <td>BWD-SEL</td> <td><input type="text" value="OFF"/></td> <td><input type="text" value="OFF"/></td> <td></td> <td><input type="text" value="0"/></td> <td><input type="text" value="0"/></td> <td>%</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td><input type="text" value="0.0"/></td> <td><input type="text" value="0.0"/></td> <td></td> </tr> </tbody> </table>		FWD	BWD		PRE TEST	acc USE		PRES	<input type="text" value="20"/>	<input type="text" value="20"/>	Bar	<input type="text" value="OFF"/>	<input type="text" value="OFF"/>		SPEED	<input type="text" value="20"/>	<input type="text" value="20"/>	%	<input type="text" value="0"/>	<input type="text" value="10"/>	Bar	BWD-SEL	<input type="text" value="OFF"/>	<input type="text" value="OFF"/>		<input type="text" value="0"/>	<input type="text" value="0"/>	%					<input type="text" value="0.0"/>	<input type="text" value="0.0"/>	
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BWD-SEL	<input type="text" value="OFF"/>	<input type="text" value="OFF"/>		<input type="text" value="0"/>	<input type="text" value="0"/>	%																														
				<input type="text" value="0.0"/>	<input type="text" value="0.0"/>																															

FIG. 7(PRIOR ART)

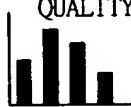
EJECT SETTING																																																			
S-EJ-F POS.: 0.0		EJ-M POS.: 0.0		S-EJ-B POS.: 0.0 mm																																															
ROTA STOP <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 20%; text-align: center;">0</td> <td style="width: 10%;">PRES</td> <td style="width: 20%; text-align: center;">140</td> <td style="width: 20%; text-align: center;">140</td> <td style="width: 20%; text-align: center;">140</td> <td style="width: 10%; text-align: right;">Bar</td> </tr> <tr> <td style="text-align: center;">0</td> <td>SPEED</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: right;">%</td> </tr> </table>		0	PRES	140	140	140	Bar	0	SPEED	0	0	0	%	ROTA-B ROTA-S ROTA-F <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 20%; text-align: center;">140</td> <td style="width: 20%; text-align: center;">140</td> <td style="width: 20%; text-align: center;">140</td> <td style="width: 10%; text-align: right;">Bar</td> </tr> <tr> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: right;">%</td> </tr> </table>		140	140	140	Bar	0	0	0	%	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="2" style="text-align: left;">EJ-FW1</th> <th colspan="2" style="text-align: left;">EJ-FW2</th> <th></th> </tr> <tr> <td style="width: 20%; text-align: center;">PRES</td> <td style="width: 20%; text-align: center;">40</td> <td style="width: 20%; text-align: center;">40</td> <td style="width: 20%; text-align: right;">Bar</td> <td></td> </tr> <tr> <td style="text-align: center;">SPEED</td> <td style="text-align: center;">60</td> <td style="text-align: center;">60</td> <td style="text-align: right;">%</td> <td></td> </tr> <tr> <td style="text-align: center;">POS.</td> <td style="text-align: center;">0.0</td> <td style="text-align: center;">0.0</td> <td style="text-align: right;">mm</td> <td></td> </tr> </table>						EJ-FW1		EJ-FW2			PRES	40	40	Bar		SPEED	60	60	%		POS.	0.0	0.0	mm			
0	PRES	140	140	140	Bar																																														
0	SPEED	0	0	0	%																																														
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SPEED	60	60	%																																																
POS.	0.0	0.0	mm																																																
F. S-EJ-B S-EJ-F <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 20%; text-align: center;">0</td> <td style="width: 20%; text-align: center;">0</td> <td style="width: 10%;">PRES</td> <td style="width: 20%; text-align: center;">0</td> <td style="width: 20%; text-align: center;">0</td> </tr> <tr> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td>SPEED</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> </tr> <tr> <td style="text-align: center;">0.0</td> <td style="text-align: center;">0.0</td> <td>POS.</td> <td style="text-align: center;">0.0</td> <td style="text-align: center;">0.0</td> </tr> </table>		0	0	PRES	0	0	0	0	SPEED	0	0	0.0	0.0	POS.	0.0	0.0	B. S-EJ-B S-EJ-F <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 20%; text-align: center;">0</td> <td style="width: 20%; text-align: center;">0</td> <td style="width: 10%;">PRES</td> <td style="width: 20%; text-align: center;">0</td> <td style="width: 20%; text-align: center;">0</td> </tr> <tr> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td>SPEED</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> </tr> <tr> <td style="text-align: center;">0.0</td> <td style="text-align: center;">0.0</td> <td>POS.</td> <td style="text-align: center;">0.0</td> <td style="text-align: center;">0.0</td> </tr> </table>		0	0	PRES	0	0	0	0	SPEED	0	0	0.0	0.0	POS.	0.0	0.0	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="2" style="text-align: left;">EJ-BWD</th> <th></th> </tr> <tr> <td style="width: 20%; text-align: center;">PRES</td> <td style="width: 20%; text-align: center;">60</td> <td style="width: 10%; text-align: right;">Bar</td> </tr> <tr> <td style="text-align: center;">SPEED</td> <td style="text-align: center;">60</td> <td style="text-align: right;">%</td> </tr> <tr> <td style="text-align: center;">POS.</td> <td style="text-align: center;">0.0</td> <td style="text-align: right;">mm</td> </tr> </table>						EJ-BWD			PRES	60	Bar	SPEED	60	%	POS.	0.0	mm
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EJECT MODE: HEPEATED EJC DELAY: 0.0 S HOLD TIME: 0.0 S EJC TIMES: 3 FIXED EJC: OFF		ROTA MODE: OFF S-EJ MODE: OFF S-EJ-F TI.: 0 S-EJ-B TI.: 0 MASK TIME: OFF PHOTOCCELL: OFF				AIR EJECT: OFF MV-MD EJ POS.: 100 mm FIXED-MD EJ TM: 2.0 sec MV-MD EJ TM: 2.0 sec CLP-END-EJ: OFF																																													

FIG. 8 (PRIOR ART)

FUNC/TIME SETTING																																																									
FUNC SWITCH 	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">ROBAT</td> <td style="width: 10%; text-align: center;"><input checked="" type="checkbox"/></td> <td style="width: 10%; text-align: center;">ON</td> <td style="width: 10%;"></td> </tr> <tr> <td>CHRG-AFT-COOLING</td> <td style="text-align: center;"><input type="checkbox"/></td> <td style="text-align: center;">OFF</td> <td></td> </tr> <tr> <td>EXHAUST</td> <td style="text-align: center;"><input type="checkbox"/></td> <td style="text-align: center;">OFF</td> <td></td> </tr> <tr> <td>REV.</td> <td style="text-align: center;"><input type="checkbox"/></td> <td style="text-align: center;">OFF</td> <td></td> </tr> </table>			ROBAT	<input checked="" type="checkbox"/>	ON		CHRG-AFT-COOLING	<input type="checkbox"/>	OFF		EXHAUST	<input type="checkbox"/>	OFF		REV.	<input type="checkbox"/>	OFF																																							
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TIMER SETTING 	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 40%;">CYCLE ALM</td> <td style="width: 10%; text-align: center;">60.0</td> <td style="width: 10%; text-align: center;">sec</td> <td style="width: 40%;">P-PRE-TEST</td> <td style="width: 10%; text-align: center;">OFF</td> <td style="width: 10%;"></td> </tr> <tr> <td>INJECT ALM</td> <td style="text-align: center;">30.0</td> <td style="text-align: center;">sec</td> <td>PRES</td> <td style="text-align: center;">50</td> <td style="text-align: right;">Bar</td> </tr> <tr> <td>CHARGE ALM</td> <td style="text-align: center;">30.0</td> <td style="text-align: center;">sec</td> <td>SPEED</td> <td style="text-align: center;">50</td> <td style="text-align: right;">%</td> </tr> <tr> <td>MIDDLE ALM</td> <td style="text-align: center;">360.0</td> <td style="text-align: center;">sec</td> <td></td> <td></td> <td></td> </tr> <tr> <td>POWER DOOR OPN</td> <td style="text-align: center;">3.0</td> <td style="text-align: center;">sec</td> <td>RECYCLE DELAY</td> <td style="text-align: center;">0.1</td> <td style="text-align: center;">sec</td> </tr> <tr> <td>F. INJECT ALM</td> <td style="text-align: center;">0.1</td> <td></td> <td>ABNDRMAL TIME</td> <td style="text-align: center;">60.0</td> <td style="text-align: center;">sec</td> </tr> <tr> <td></td> <td></td> <td></td> <td>PHOTOCCELL</td> <td style="text-align: center;">6.0</td> <td style="text-align: center;">sec</td> </tr> <tr> <td></td> <td></td> <td></td> <td>EXHAUST TM</td> <td style="text-align: center;">0.1</td> <td style="text-align: center;">sec</td> </tr> <tr> <td></td> <td></td> <td></td> <td>F. CHARGE ALM</td> <td style="text-align: center;">0.1</td> <td></td> </tr> </table>			CYCLE ALM	60.0	sec	P-PRE-TEST	OFF		INJECT ALM	30.0	sec	PRES	50	Bar	CHARGE ALM	30.0	sec	SPEED	50	%	MIDDLE ALM	360.0	sec				POWER DOOR OPN	3.0	sec	RECYCLE DELAY	0.1	sec	F. INJECT ALM	0.1		ABNDRMAL TIME	60.0	sec				PHOTOCCELL	6.0	sec				EXHAUST TM	0.1	sec				F. CHARGE ALM	0.1	
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COMMUNICATION 	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 40%;">ST_NO:</td> <td style="width: 10%; text-align: center;">1</td> <td style="width: 20%;">BAUD:</td> <td style="width: 10%; text-align: center;">9600</td> <td style="width: 10%; text-align: center;">BPS</td> </tr> <tr> <td>PROTOCOL:</td> <td style="text-align: center;">PIS</td> <td colspan="3">COM_FUN: DISABLE</td> </tr> </table>			ST_NO:	1	BAUD:	9600	BPS	PROTOCOL:	PIS	COM_FUN: DISABLE																																														
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FIG. 9 (PRIOR ART)

◀
PRODUCT INFORMATION
▶

<b>QUALITY CTL</b> 	MATERIAL: <span style="background-color: black; color: black;">████████</span>		MOLD: MOLD1		SAVE
	MOLD SEARCH:		LOAD	CLEAR	
	POWER TIME: 0 HR		AUTO-WORK T 0.0 HR		

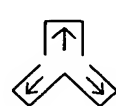
	TOTAL_NO	GOOD_NO	BAD_NO	CAVITY_NO	BOX NUMBER	MOLD WEIGHT
PROD_TAR	1000	1000	20	5	1	MD 8.8 G
CURR_NO	10111	20222	123	CNT_BAD	0	MD PCS WT
STOP_SEL	OFF	OFF	OFF	OFF	OFF	1.0 G
	CNTR RES		BAD RST		RESET	

CUSHION	0.0	mm	INJ. TM	CHRG TM	CYCLE TM	
Q.C. VALUE	11.0	mm	6.00	10.0	30.0	sec
TOLERANCE	3.0	mm	1.50	2.0	2.0	sec
MEAN	0.0	mm	0.00	0.0	0.0	sec
STD DEV.	0.0	mm	0.00	0.0	0.0	sec
SELECT	OFF		OFF	OFF	OFF	

FIG. 10(PRIOR ART)

◀
CORE SETTING
▶

MOLD POS.: 0.5 mm

	CORE 1	TYPE: <input checked="" type="checkbox"/> CORE	CORE-IN	CORE-OUT1	CORE-OUT2	
		SELECT	OFF	OFF	OFF	
		PRES	40	40	40	Bar
		SPEED	40	40	40	%
		POS.	300	0	600	mm
		TIME	0.0	0.0	0.0	sec
		TEETH	1	1	1	PS
		SENSOR SW	OFF	OFF	OFF	


	CORE 2	TYPE: CORE	CORE-IN	CORE-OUT1	CORE-OUT2	
		SELECT	OFF	OFF	OFF	
		PRES	40	40	40	Bar
		SPEED	40	40	40	%
		POS.	299	1	600	mm
		TIME	0.0	0.0	0.0	sec
		TEETH	1	1	1	PS
		SENSOR SW	OFF	OFF	OFF	

FIG. 11(PRIOR ART)

◀
AUTO PURGE/CARR.
▶

B. INJECT POS.: 0. 0
F. INJECT POS.: 0. 0 mm

AUTO PURGE	REPEATED-SEL: <input checked="" type="checkbox"/> B. INJ REPEATED TIME: <input style="width: 50px;" type="text" value="5"/>																								
	<table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 20%;">SLOW</th> <th style="width: 20%;">FAST</th> <th style="width: 10%;"></th> <th style="width: 20%;">SUCKBACK</th> <th style="width: 20%;">CHARGE</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">40</td> <td style="text-align: center;">40</td> <td rowspan="3" style="padding: 0 10px;">PRES SPEED POS.</td> <td style="text-align: center;">40</td> <td style="text-align: center;">50</td> </tr> <tr> <td style="text-align: center;">20</td> <td style="text-align: center;">60</td> <td style="text-align: center;">30</td> <td style="text-align: center;">50</td> </tr> <tr> <td style="text-align: center;">11. 0</td> <td style="text-align: center;">30. 0</td> <td style="text-align: center;">60</td> <td style="text-align: center;">0. 0</td> </tr> <tr> <td></td> <td style="text-align: center;">mm</td> <td></td> <td style="text-align: center;">mm</td> <td style="text-align: center;">sec</td> </tr> </tbody> </table>		SLOW	FAST		SUCKBACK	CHARGE	40	40	PRES SPEED POS.	40	50	20	60	30	50	11. 0	30. 0	60	0. 0		mm		mm	sec
	SLOW	FAST		SUCKBACK	CHARGE																				
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20	60		30	50																					
11. 0	30. 0		60	0. 0																					
	mm		mm	sec																					
<div style="text-align: center;">CARRIAGE</div> <table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 10%;"></th> <th style="width: 20%;">FWD</th> <th style="width: 20%;">BWD</th> <th style="width: 10%;"></th> </tr> </thead> <tbody> <tr> <td rowspan="3" style="padding: 0 10px;">◀ PRES SPEED BWD-SEL ▶</td> <td style="text-align: center;">40</td> <td style="text-align: center;">40</td> <td rowspan="3" style="padding: 0 10px;">Bar % ▶</td> </tr> <tr> <td style="text-align: center;">20</td> <td style="text-align: center;">20</td> </tr> <tr> <td></td> <td style="text-align: center;">ON</td> </tr> </tbody> </table>			FWD	BWD		◀ PRES SPEED BWD-SEL ▶	40	40	Bar % ▶	20	20		ON												
	FWD	BWD																							
◀ PRES SPEED BWD-SEL ▶	40	40	Bar % ▶																						
	20	20																							
		ON																							

FIG. 12(PRIOR ART)

◀
B: INJ /CHRG SETTING
▶

CHRG LIMIT: 470.0 mm
INJ. POS.: 0. 0 mm

INJECTION USE.: ☒ OFF
SUCK MODE: ON
COOL TM: 3.0 sec

INJECT  ◀	<table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th style="width: 20%;">INJ 5</th> <th style="width: 20%;">INJ 4</th> <th style="width: 20%;">INJ 3</th> <th style="width: 20%;">INJ 2</th> <th style="width: 20%;">INJ 1</th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: center;">20</td> <td style="text-align: center;">60</td> <td style="text-align: center;">111</td> </tr> <tr> <td>SPEED</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: center;">20</td> <td style="text-align: center;">99</td> <td style="text-align: center;">99</td> </tr> <tr> <td>POS.</td> <td style="text-align: center;">0. 0</td> <td style="text-align: center;">*****</td> <td style="text-align: center;">10. 0</td> <td style="text-align: center;">50. 0</td> <td style="text-align: center;">96. 0</td> </tr> <tr> <td>TIME</td> <td colspan="5" style="text-align: center;">0. 00</td> </tr> </tbody> </table>						INJ 5	INJ 4	INJ 3	INJ 2	INJ 1	PRES	0	0	20	60	111	SPEED	0	0	20	99	99	POS.	0. 0	*****	10. 0	50. 0	96. 0	TIME	0. 00					Bar % mm sec
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		HOLD 4	HOLD 3	HOLD 2	HOLD 1																															
	PRES	0	0	20	111																															
	SPEED	0	0	20	21																															
TIME	0. 0	0. 0	0. 0	0. 0																																
CHARGE  ↻	<table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th style="width: 20%;">CHRG1-BP</th> <th style="width: 20%;">CHRG2-BP</th> <th style="width: 20%;">CHRG3-BP</th> <th style="width: 20%;">POSTSCK</th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: center;">60</td> </tr> <tr> <td>SPEED</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: center;">60</td> <td style="text-align: center;">20</td> </tr> <tr> <td>SYS-PRES</td> <td colspan="3" style="text-align: center;">0</td> <td style="text-align: center;">Bar</td> </tr> <tr> <td>POS.</td> <td style="text-align: center;">0. 0</td> <td style="text-align: center;">0. 0</td> <td style="text-align: center;">60. 0</td> <td style="text-align: center;">+ 99 mm</td> </tr> </tbody> </table>					CHRG1-BP	CHRG2-BP	CHRG3-BP	POSTSCK	PRES	0	0	0	60	SPEED	0	0	60	20	SYS-PRES	0			Bar	POS.	0. 0	0. 0	60. 0	+ 99 mm	Bar % Bar mm						
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	PRES	0	0	0	60																															
	SPEED	0	0	60	20																															
SYS-PRES	0			Bar																																
POS.	0. 0	0. 0	60. 0	+ 99 mm																																

FIG. 13(PRIOR ART)